

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015360**Date Inspected:** 03-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Le Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

OBG # BAY 3

This QA inspector received ZPMC Non Destructive Testing (NDT) notification 06112 to perform Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated a Ultrasonic Test report for this date. The member is identified as Floor beam. The weld tested is identified as follows:

(FB3109-001-011,012)

(FB3121-001-019,020)

This QA Inspector randomly observed the following work in progress:

OBG # BAY 1

This QA observed ZPMC qualified welding personnel identified as 203710 perform Flux Cored Arc Welding (FCAW) Process on weld joint 21TR2-002-001. ZPMC Quality Control Personnel (QC) identified as Mr. Ai wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1 and Weld Repair

WELDING INSPECTION REPORT

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Report B-WR13819.

This QA observed ZPMC qualified welding personnel identified as 216872 perform Flux Cored Arc Welding (FCAW) Process on weld joint 21TR2-018-003. ZPMC Quality Control Personnel (QC) identified as Mr. Ai wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-1G (1F)-Repair-1 and Weld Repair Report B-WR13810.

OBG # BAY 2

This QA observed ZPMC qualified welding personnel identified as 045203 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3187-001-028,030. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-3.

This QA observed ZPMC qualified welding personnel identified as 058245 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3193-001-177,178. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U5-F-2.

This QA observed ZPMC qualified welding personnel identified as 045280 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3186-001-011,012. ZPMC Quality Control Personnel (QC) identified as Mr. Zhu Jun was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U5-F-2.

OBG # BAY 3

This QA observed ZPMC qualified welding personnel identified as 044824 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3150-001-006. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Hai Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-TC-U4b-F

This QA observed ZPMC qualified welding personnel identified as 044790 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3157-001-010. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Hai Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 217805 perform Flux Cored Arc Welding (FCAW) Process on weld joint FB3108-001-070. ZPMC Quality Control Personnel (QC) identified as Mr. Zhang Hai Feng was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F.

During in process visual inspection, this QA inspector observed ZPMC Magnetic particle Testing (MT) technicians perform MT on Traveler rail weld joints. See attached pictures.

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Bay # 3

Traveler Rail

10TR3-023

07/03/10 -1019



This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer